

ABSTRACT OF THE DISCLOSURE

A coated turning insert particularly useful for turning in stainless steel is disclosed.

914 The insert is characterized by a WC-Co-based cemented carbide substrate having a highly W-alloyed Co-binder phase and a coating including an inner layer of  $\text{TiC}_x\text{N}_y\text{O}_z$  with columnar grains followed by a layer of fine-grained  $\kappa\text{-Al}_2\text{O}_3$  and a top layer of TiN. The layers are deposited by using CVD-methods.

09077424-090198